

Date: Friday, 16/05/2008 2:31:02 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 39331		
Estimate Number	: 13273		
P.O. Number	:	Part Number	: D32023
This Issue	: 16/05/2008	Drawing Number	: D3202 REV C PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: C PRELIM
Previous Run	: 38789	Material	:
Written By	<i>Jean-Luc Menard 05.16.</i>	Due Date	: 23/05/2008
Checked & Approved By		Qty:	1
Comment	: Est Rev:A new issue 08-04-21 DD verified by:EC	Um:	Each

Additional Product

*PROTENGINERING APPROVAL***PROTOTYPE**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S032 <i>000</i>	5052-H32 .032 Sheet
	Comment: Qty.: 1.6286 sf(s)/Unit Total : 1.6286 sf(s) 5052-H32 .032 Sheet Batch: 107513 <i>IB 8-5-20</i>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3202 Dwg Rev: <i>C</i> <i>IB 8-5-20</i> Prog Rev: <i>C</i> <i>IB 8-5-20</i>	<i>(1)</i>
	2-Deburr if necessary <i>IB 8-5-20</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK ENGINEERING APPROVAL <i>AS 08.05.20</i>
	Comment: SECOND CHECK	<i>JL</i> <i>08-05-20</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

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Description :

6.0 POWDER COATING



POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

2/28/08 JLM

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

7.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SAC to Eagle D.W.C.

9.0 QC21

FINAL INSPECTION/W/O RELEASE

*08/08/2008*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

*Plan of To W/O VO 220**U.S. 05.20*

8

7

6

5

4

3

2

1

D

D

C

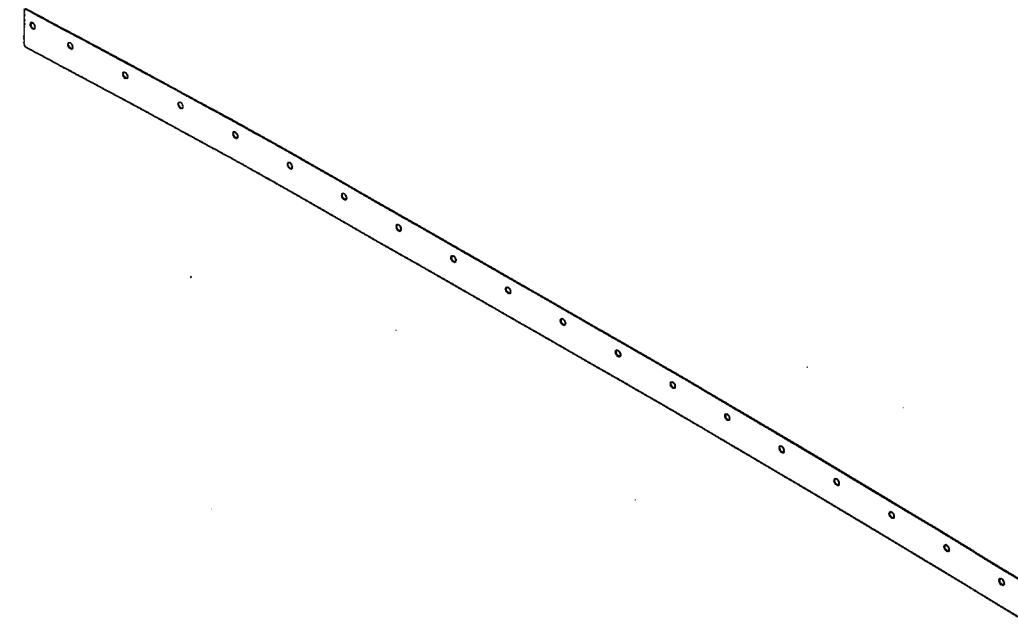
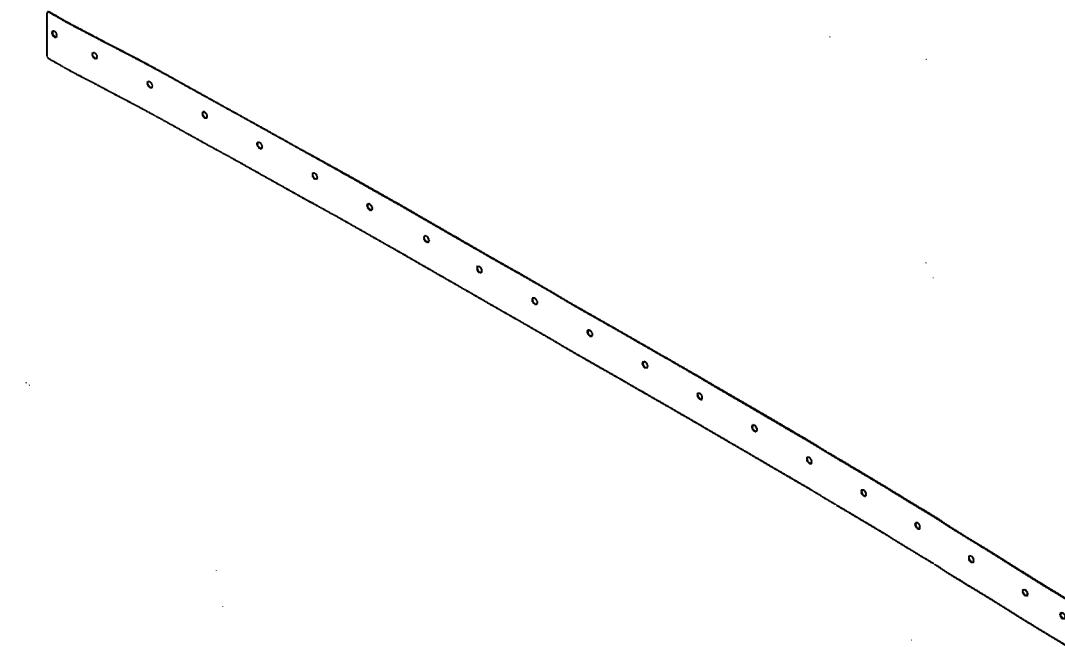
C

B

B

NOTES:

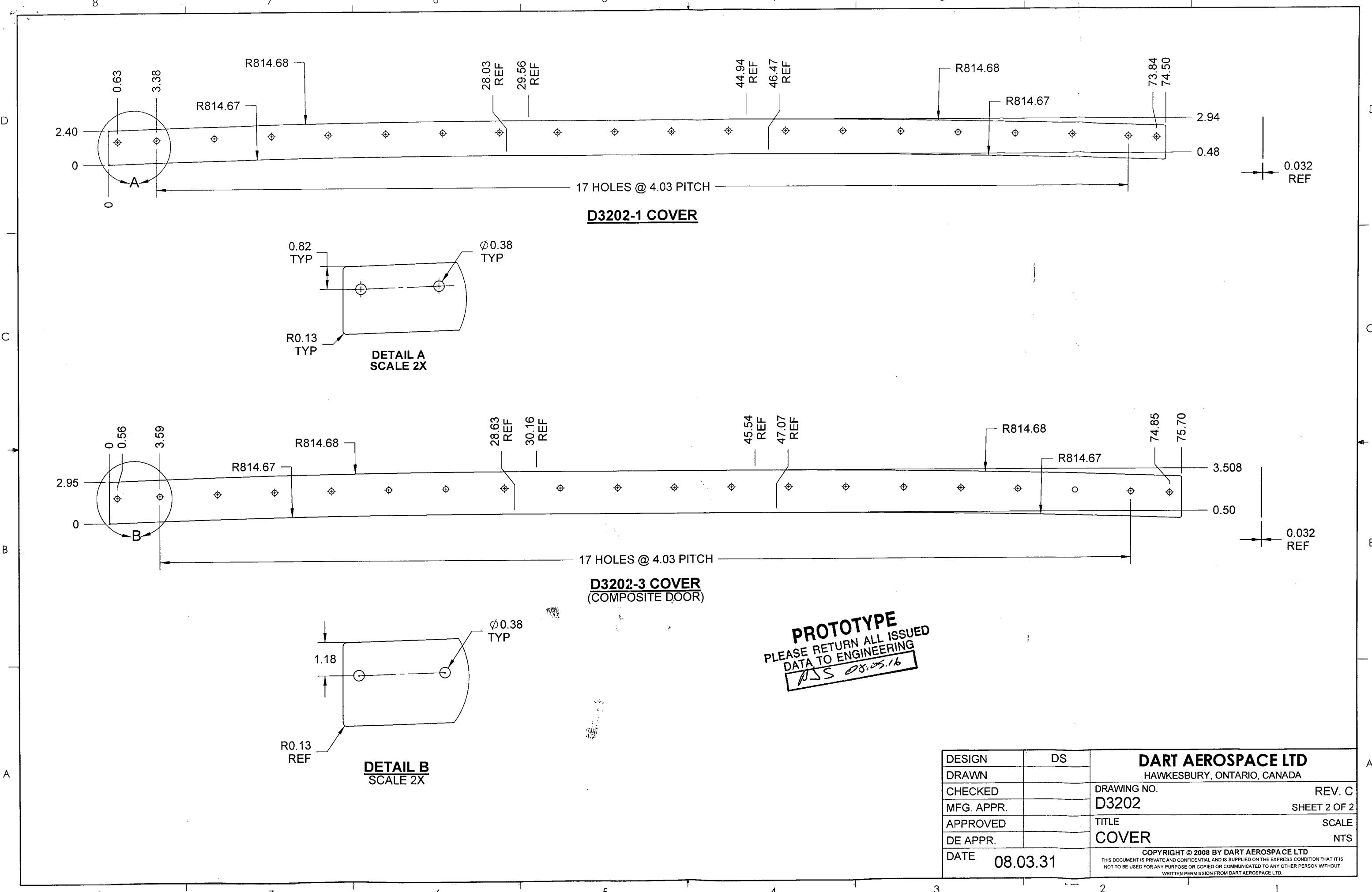
- 1) MATERIAL: 5052-H32/H34 ALUMINUM ALLOY SHEET, 0.032 THICK
PER QQ-A-250/8
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1
0.61 lbs APPROX FOR -3

D3202-1 COVERD3202-3 COVER
(COMPOSITE DOOR)

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

ASS 08.05.16

C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)			AJS	08.03.31
B	RE-DESIGN PART NOW CURVED			CP	03.10.16
A	NEW ISSUE			CP	01.01.01
REV.	DESCRIPTION			BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED					
MFG. APPR.		DRAWING NO.		REV. C	
APPROVED		D3202		SHEET 1 OF 2	
DE APPR.		TITLE		SCALE	
DATE	08.03.31	COVER		NTS	
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PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-698

Job #: 00220

Date: 16-May-08

Product Name: Cabin Door Roller Kit (Comp Door)

Requested By: AJS

Design Manager Approval:

DART AEROSPACE LTD	Work Order:	39331
Description: COVER	Part Number:	D3202-3
Inspection Dwg: D3202-2 Rev: A C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: HB	Audited by: J.W.	Prototype Approval: AS
Date: 8-5-20	Date: 08.05.20	Date: 08.05.20

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	